

Date: Wednesday, 1/18/2006 4:04:08 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER ASSEMBLY
Job Number : 25552	
Estimate Number : 10295	
P.O. Number : N/A	Part Number : D3220042
This Issue : 1/18/2006 S.O. No. : N/A	Drawing Number : D3220 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 24956C	Material : N/A
Written By : <u>SEE COMMENT BELOW.</u>	Due Date : 2/5/2006 Qty: 10 Um: Each
Checked & Approved By : <u>SEE ABOVE USER & DATE.</u>	
Comment : Est Rev:A New Issue 05-11-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.7266 sf(s)/Unit Total: 7.2660 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick
 (M2024T3S.050
 Identify for D3220-2
 Batch: M19053

ml 06/02/28 10

2.0	SHEAR	SHEAR
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Comment: Cut blank: 14.250" x 7.000" grain along 14.250"

ml 06/02/28 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine D3220-2 as per Folio FA362 and Dwg D3220 Stack of 5
 identify as D3220-2

ml 06/02/28 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/02/28 10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

MS 06/02/28 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:04:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 25552

Part Number: D3220042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr SAD 06:02:28 (10)

2-C'sink D3220-2 as per Dwg D3220 SAD 06:03:20 (9) 1

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 SAD 06:03:02 (9) 1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

MS20426AD34

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

8 MS20426AD3-4

Rivet

M15786

11.0

MS21059L4

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 MS21059L4

Nutplate

M19522

SAD 06:03:02 (9) 1

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1



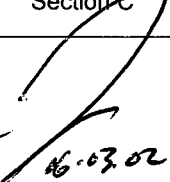

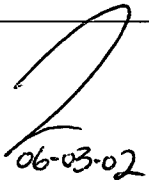
Assemble D3220-042 doubler as per Dwg D3220

SAD 06:03:02 (9) 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 06/03/08

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-03-02	6	9 parts C'sunk on wrong Side. Part is now A now A - 1	 06-03-08 pr 051 042	Create A w/o for 03220 - 041 Qty of 9	 06-03-02	 06-03-02	 06-03-08 pr 051 042	 06-03-02

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:04:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 25552

Part Number: D3220042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



20603.06

Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

st 93

20603/08 (1)

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

20603/08

Job Completion



u 06-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

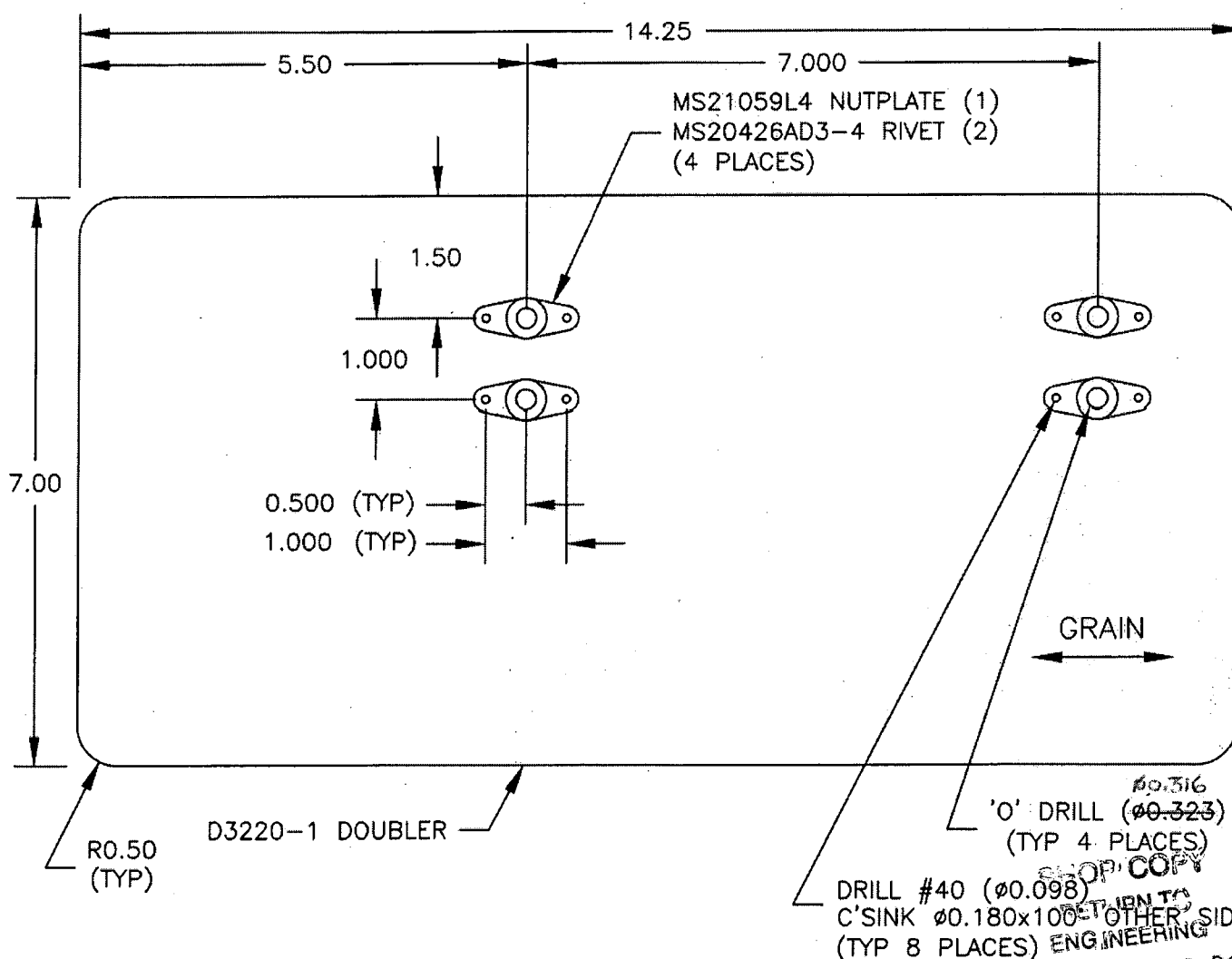
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3220
				REV. A
DATE	03.10.16	TITLE	DOUBLER	SHEET 1 OF 2
				SCALE 1:2
A	03.10.16	NEW ISSUE		
A1	<i>CP</i> 03.11.13	CORRECTED DIM.		

RELEASED
03.11.14 *[Signature]*



D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER)

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WITHOUT NOTICE

WORK ORDER

NO. 25552

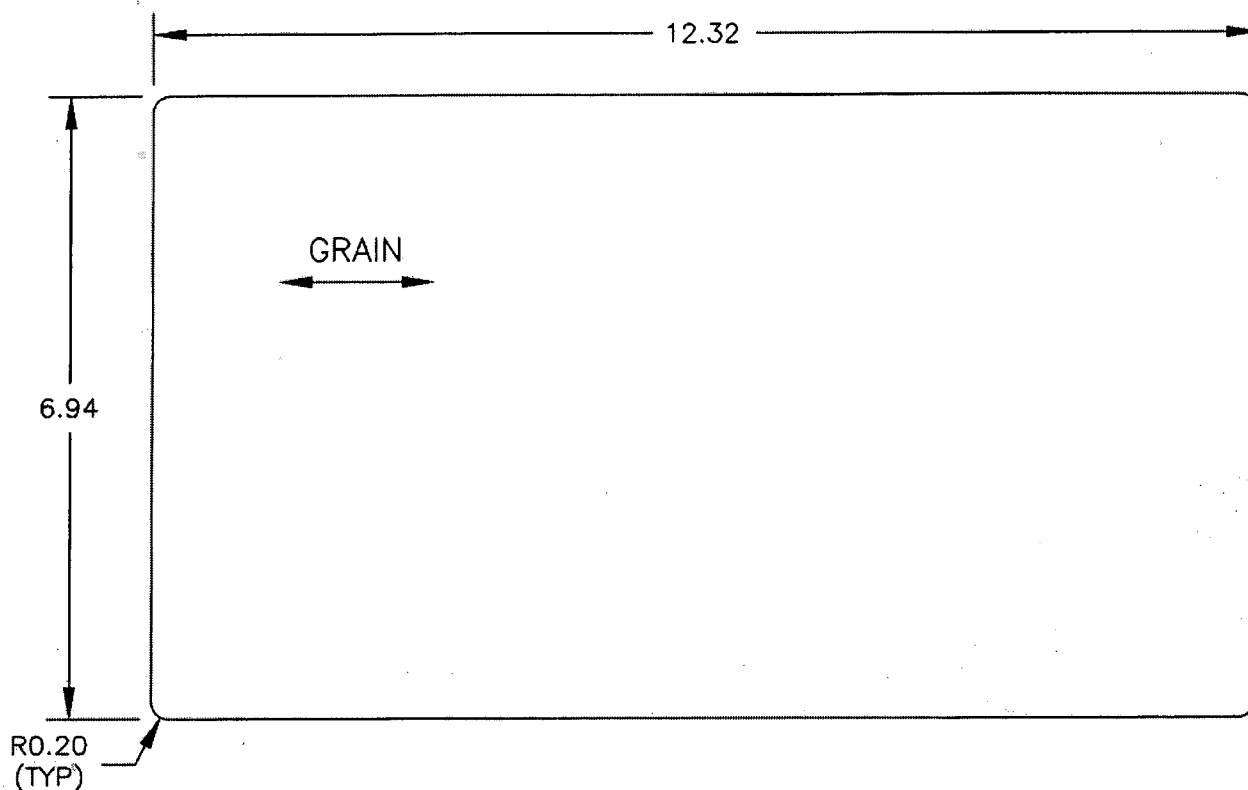
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3220	REV. A SHEET 2 OF 2
DATE 03.10.16		TITLE DOUBLER	SCALE 1:2

RELEASED
03.11.14 *[Signature]*



D3220-3 DOUBLER

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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